

Date: Monday, 3/20/2006 11:39:41 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR SUPPORT
Job Number : 26268	
Estimate Number : 12309	
P.O. Number : N/A	Part Number : D3471043
This Issue : 3/20/2006 S.O. No. : N/A	Drawing Number : D3471 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26268	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/31/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: <u>2</u> Um: Each
Comment : est rev A 06.03.02 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS3584216	CLAMP
-----	-----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
2	MS35842-16	CLAMP	B19691

(2)

2.0	MS20427M44	RIVET
-----	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
6	MS20427M4-4	Rivet	M100393

(6)

3.0	D34713	SUPPORT
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 pick:

Qty	Part number	Description	Batch
2	D3471-3	Support	B 26124

(2)

SB 06/03/29

(2)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

SB 06/03/29

(2)

Date: Monday, 3/20/2006 11:39:42 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26268

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/03/29 (2)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/29 (2)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/03/30 (2)

Job Completion



CR 06-03-30

Date: Thursday, 3/16/2006 10:37:40 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 26268		
Estimate Number	: 12309		
P.O. Number	:	Part Number	: D3471043
This Issue	: 3/16/2006 S.O. No. :	Drawing Number	: D3471 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 3/31/2006 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: est rev A 06.03.02 New issue EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MS3584216

CLAMP



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
CLAMP

Job Completion



Eric
could you
please complete
and let me
know when
done
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

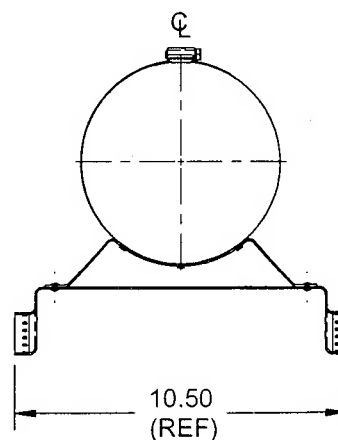
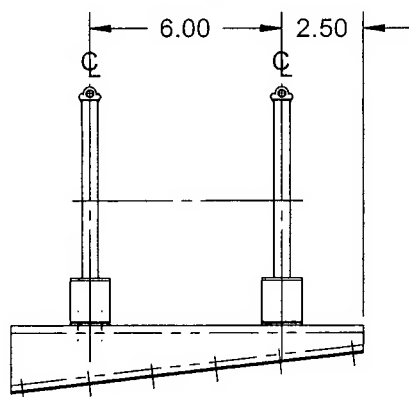
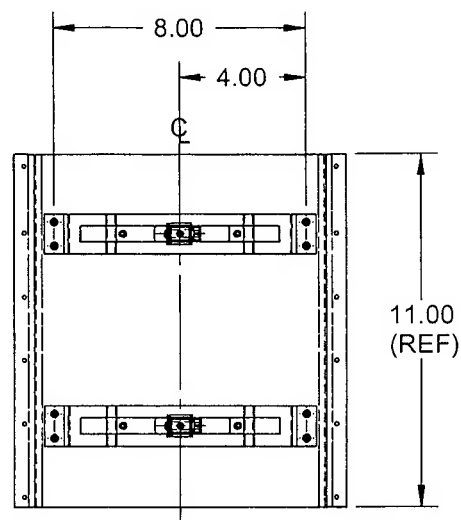
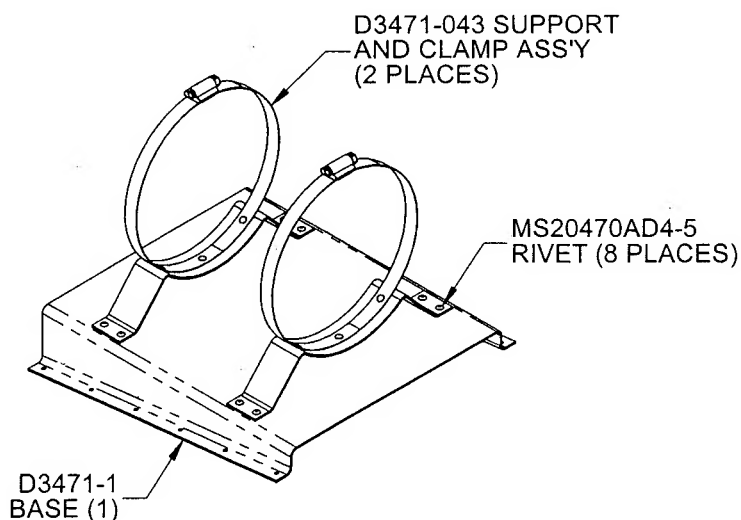
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/20	4	2 elamp u. 35842-16 + 1 D 3471-3 were scrap	<i>[Signature]</i> GARDIN	snag & destroy replace it	GB 06/03/20	<i>[Signature]</i> GARDIN	<i>[Signature]</i> GARDIN	<i>[Signature]</i> GARDIN

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21	TITLE BLOWER MOTOR SUPPORT		SCALE 1:6
A	05.12.21	NEW ISSUE	



D3471-041 BLOWER MOTOR SUPPORT

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

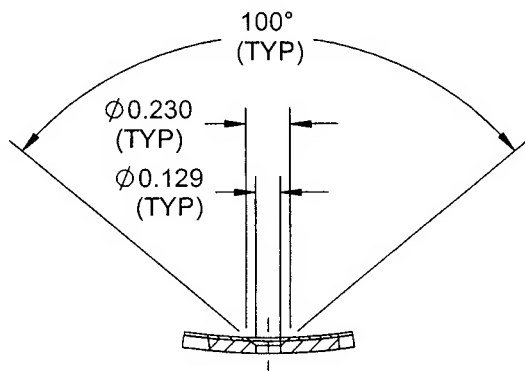
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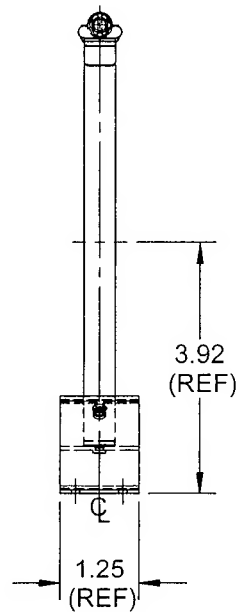
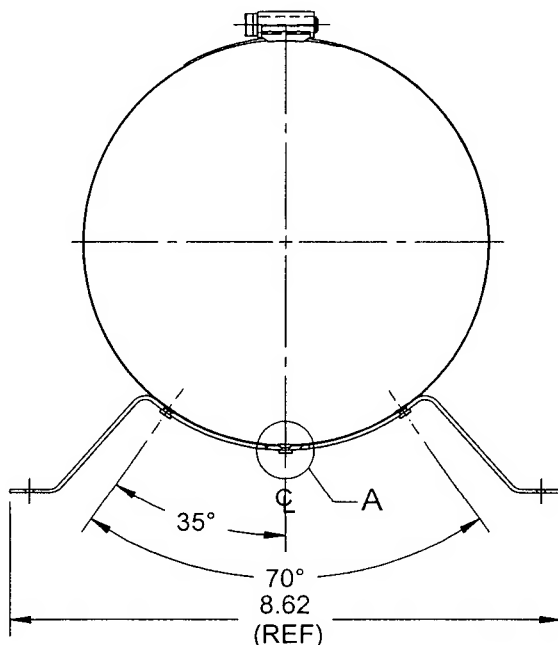
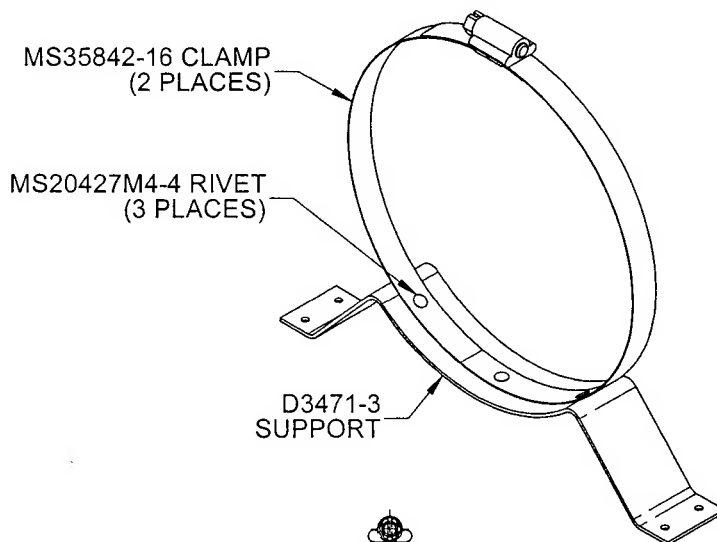
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CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 2 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	
		SCALE 1:3	



DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1



D3471-043 SUPPORT AND CLAMP ASS'Y

NOTES:

- 1) LOCATE MS35842-16 CLAMP AND TRANSFER DRILL #30 (0.129") HOLES FROM D3471-3 TO MS35842-16 CLAMP. COUNTERSINK AS SHOWN IN DETAIL A (3 PLACES).
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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

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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	
		SCALE 1:4	

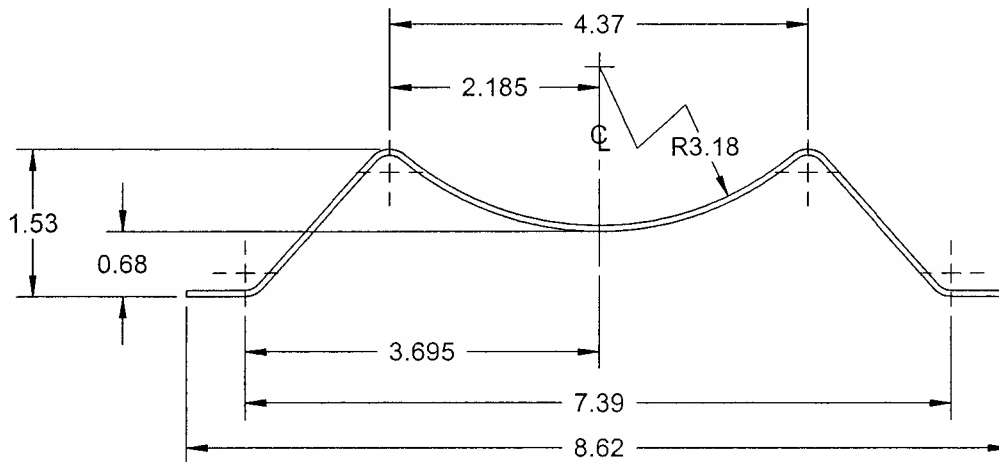
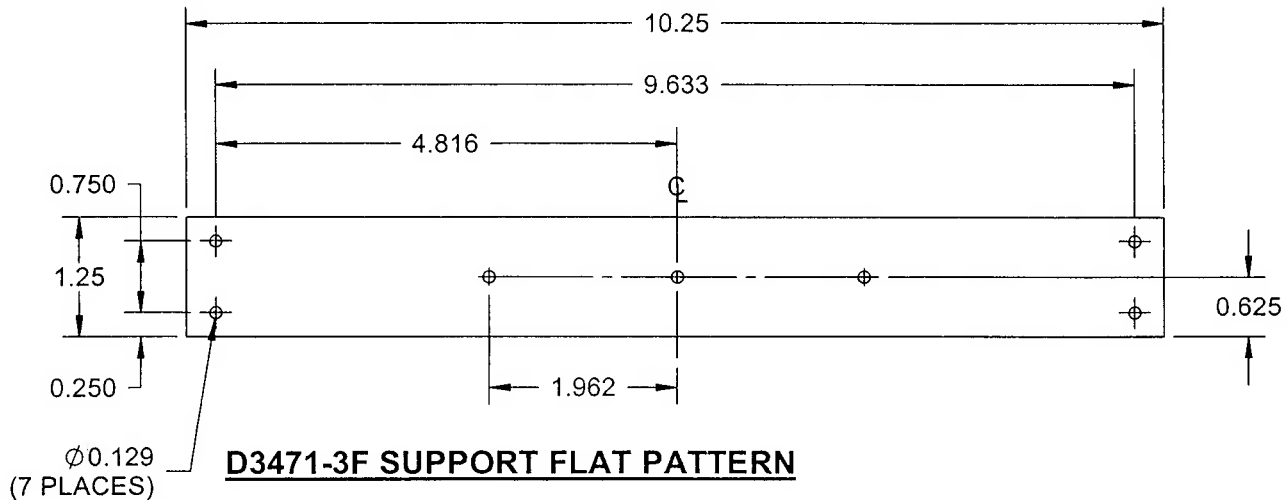


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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:2



D3471-3 SUPPORT BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

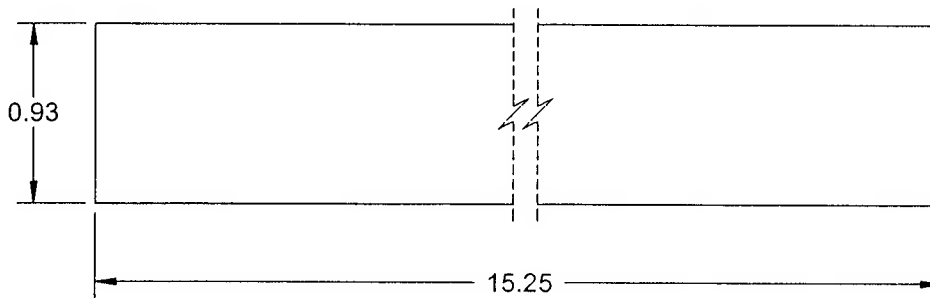
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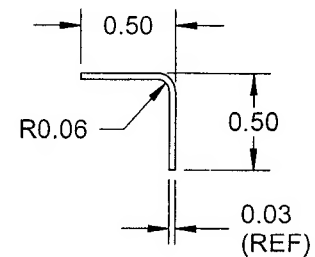
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:1



D3471-5F STIFFENER FLAT PATTERN



**D3471-5 STIFFENER
BENDING DETAIL**

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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